

Thursday, 9/21/2006 3:24:06 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLUG		
Job Number	: 28692					
Estimate Number	: 12292					
P.O. Number	: N/A		Part Number	: D26513		
This Issue	: 9/21/2006 S.O. No. : N/A		Drawing Number	: D2651 REV.B		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B		
Previous Run	: 28401		Material	: N/A		
Written By			Due Date	: 10/3/2006 Qty: 300 Um: Each		
Checked & Approved By						
Comment	: est rev. A 06/02.15 new issue EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	PG	PURCHASING		
		Comment: PURCHASING Issue P/O: 2112 Purchase P/N: 2-008 as per Dwg D2651 Supplier: Parker Ensure Certificate of Conformity is attached	c 06/09/25	(300)
2.0	MS28775008	O RING		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 300.0000 Each(s) O RING		
3.0	PACKAGING 1	PACKAGING RESOURCE #1		
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached	J 4/5/27	300
4.0	QC6	DIMENSIONAL CHECK		
		Comment: DIMENSIONAL CHECK Ensure Material certification comply to Dwg D3446	J 6/5/28	(300)
5.0	PACKAGING 1	PACKAGING RESOURCE #1		
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: STS4	P 06/09/28	(300)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/07/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PLUG

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Seq. #:

Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



303

Comment: FINAL INSPECTION/W/O RELEASE

SP 06/09/08

Job Completion



U 0609-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



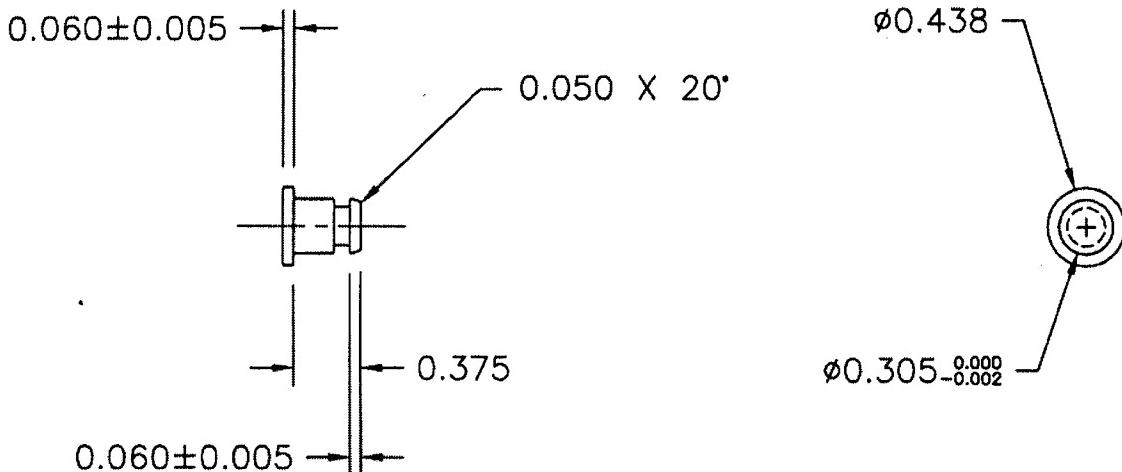
OF COPY ISSUE
CENCO

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2651	SHEET 1 OF 1
DATE		TITLE	SCALE
03.12.19		PLUG	1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

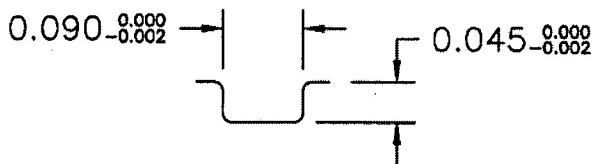
RELEASED

03.12.19 *[Signature]*

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ~~BREAK ALL SHARP EDGES 0.010 MAX~~

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28692

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Parker Hannifin Corporation
O-Ring Division
P.O. Box 2276
Brownsville, TX 78522
Phone: (859) 335-3000

**— NOTICE —
This is a C.B.I. Compound!**

C.B.I. is Parker's exclusive quality assurance program for Controlled Batch Identification, your assurance of reliability.

CONFORMANCE CERTIFICATE FOR MATERIAL SHIPPED

Parker O-Ring Division certifies that the material used in the manufacture of the parts identified below and called for on Purchase Order Number 176110 received by us from SWAN ENGINEERING & SUPPLY is traceable to C.B.I. Number 80024701 and that the material used conforms to the requirements of the specifications indicated below. The tests were performed in accordance with these specifications, and data supporting the indicated results are on file.

CUSTOMER PART NUMBER	PARKER PART NUMBER	COMPOUND	QUANTITY	CURE DATE	SHIP DATE
MS28775-008.	2-008	N0304 -75	10000	3Q04	10/07/04
TESTED AS: 2-214					
PHYSICAL PROPERTIES	REQUIREMENTS	VARIATION	PARKER FINDINGS		
SPECIFICATION MIL-P-25732C	TYPE	CLASS	TEST DT	09/04/04	
ASTMD297 SPECIFIC GRAVITY		(1.26 - 1.30)	-	1.2800	
ASTMD2240 HARDNESS SHORE A	(68 - 80)	(70 - 80)	75		
ASTMD1414 TENSILE STRENGTH, PSI	1350 MIN	(1440 - 2160)	1916		
ASTMD1414 ELONGATION, %	160 MIN	(160 - 226)	225		
MODULUS AT 100% ELONG.	500 MIN	(500 - 9999)	545		
TR-10 50% ELONG. 10%RETURN	-49 MAX	-	-53.0		
FLUID AGEING 70 HRS AT					
275F IN MIL H-5606					
ASTMD395 COMPRESSION SET % MAX	55		33.3		
TR-10	-49 MAX		-53.0		
ASTMD2240 HARDNESS CHANGE	+5 -15		-12.0		
VOLUME CHANGE	-1 -20		18.8		

No Mercury, Mercury compounds or Mercury bearing instruments, equipment or apparatus which might cause contamination has been used in the manufacture or subsequent processing of material covered by this order.

Purchaser use only. Reproduce only in full. Data pertains to items referenced.

The recording of false, fictitious or fraudulent statements or entries on the certificate may be punishable as a felony under federal law.

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O-Ring Division
PARKER HANNIFIN CORPORATION

By _____

Ruben Ramirez
Quality Assurance Manager